

009931



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D4775-041**  
**Job Sheet 194853**



Part No: D4775-041

Job Qty: 6 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 6/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

**Note:** DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD  
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD  
VERF:JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off |
|----------|------------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|----------|
|          |                        |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |          |
| 110      | Packaging 1 - Pick Kit | 6 pcs | 6/26/19    |             | 0.00         | 0.00       | Packaging 1 - 1       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 2       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 3       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 4       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 5       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 6       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 7       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 8       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 9       |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 10      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 11      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 12      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 13      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 14      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 15      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 16      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 17      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 18      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 19      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 20      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 21      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 22      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 23      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 24      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 25      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 26      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 27      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 28      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 29      |           |          |
|          |                        |       |            |             |              |            | Packaging 1 - 30      |           |          |

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|                                 |       |         |           |  |                        |  |
|---------------------------------|-------|---------|-----------|--|------------------------|--|
|                                 |       |         |           |  | Packaging 1 - 31       |  |
|                                 |       |         |           |  | Packaging 1 - 32       |  |
|                                 |       |         |           |  | Packaging 1 - 33       |  |
|                                 |       |         |           |  | Packaging 1 - 34       |  |
|                                 |       |         |           |  | Packaging 1 - 35       |  |
|                                 |       |         |           |  | Packaging 1 - 36       |  |
|                                 |       |         |           |  |                        |  |
| 120 Small Fab - 2 - B4B         | 6 pcs | 6/26/19 | 0.00 2.49 |  | Small Fab - 1 - B4B    |  |
|                                 |       |         |           |  | Small Fab - 2 - B4B    |  |
|                                 |       |         |           |  | Small Fab - 3 - B4B    |  |
|                                 |       |         |           |  | Small Fab - 4 - B4B    |  |
|                                 |       |         |           |  | Small Fab - 5 - B4B    |  |
|                                 |       |         |           |  | Small Fab - 6 - B4B    |  |
|                                 |       |         |           |  | Small Fab - 7 - B4B    |  |
| 130 QC 5                        | 6 pcs | 6/26/19 | 0.00 0.00 |  | QC 5 - 10              |  |
|                                 |       |         |           |  | QC 5 - 12              |  |
|                                 |       |         |           |  | QC 5 - 17              |  |
|                                 |       |         |           |  | QC 5 - 18              |  |
|                                 |       |         |           |  | QC 5 - 19              |  |
|                                 |       |         |           |  | QC 5 - 22              |  |
|                                 |       |         |           |  | QC 5 - 24              |  |
|                                 |       |         |           |  | QC 5 - 3               |  |
|                                 |       |         |           |  | QC 5 - 43              |  |
|                                 |       |         |           |  | QC 5 - 49              |  |
|                                 |       |         |           |  | QC 5 - 51              |  |
|                                 |       |         |           |  | QC 5 - 58              |  |
|                                 |       |         |           |  | QC 5 - 68              |  |
|                                 |       |         |           |  | QC 5 - 9               |  |
|                                 |       |         |           |  | QC 5 - 50              |  |
|                                 |       |         |           |  | QC 5 - 30              |  |
|                                 |       |         |           |  | QC 5 - 40              |  |
| 140 Packaging 3-1 - Stock - B4B | 6 pcs | 6/26/19 | 0.00 0.00 |  | Packaging 3 - 1 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 2 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 3 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 4 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 5 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 6 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 7 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 8 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 9 - B4B  |  |
|                                 |       |         |           |  | Packaging 3 - 10 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 11 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 12 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 13 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 14 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 15 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 16 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 17 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 18 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 19 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 20 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 21 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 22 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 23 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 24 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 25 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 26 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 27 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 28 - B4B |  |
|                                 |       |         |           |  | Packaging 3 - 29 - B4B |  |

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DAS  
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9-89

PC ST357

|                |       |         |      |      |                        |      |
|----------------|-------|---------|------|------|------------------------|------|
|                |       |         |      |      | Packaging 3 - 30 - B4B |      |
|                |       |         |      |      | Packaging 3 - 31 - B4B |      |
|                |       |         |      |      | Packaging 3 - 32 - B4B |      |
|                |       |         |      |      | Packaging 3 - 33 - B4B |      |
|                |       |         |      |      | Packaging 3 - 34 - B4B |      |
|                |       |         |      |      | Packaging 3 - 35 - B4B |      |
|                |       |         |      |      | Packaging 3 - 36 - B4B |      |
| 150 QC 21 - SA | 6 pcs | 6/26/19 | 0.00 | 0.00 | QC 21 - SA - 21        | DAS  |
|                |       |         |      |      | QC 21 - SA - 70        | 21   |
|                |       |         |      |      | QC 21 - SA - 53        | 2-68 |

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## Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL

BATCH: \_\_\_\_\_ 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

150 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item  | Component Name      | Quantity      | Operation                  | Container       |
|--------------|---------------------|---------------|----------------------------|-----------------|
| AN3-10A      | Bolt                | 12 Ea (2 ea)  | 110-Packaging 1 - Pick Kit | 2179612         |
| D4775-1      | Strut Tube          | 6 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 2175163         |
| D4776-1      | Basket Strut Clevis | 6 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 2175961         |
| D4776-5      | Spacer              | 24 pcs (4 ea) | 110-Packaging 1 - Pick Kit |                 |
| D4777-1      | Rod End Bearing     | 6 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 2169675 2165879 |
| MS21042L3    | Nut                 | 12 Ea (2 ea)  | 110-Packaging 1 - Pick Kit | 2166712         |
| MS21209-F615 | Heli-Coil           | 6 Ea (1 ea)   | 110-Packaging 1 - Pick Kit | 2152919         |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | AN3-10A        | 12       | 145       | 0         |
|                            | D4775-1        | 6        | 27        | 0         |
|                            | D4776-1        | 6        | 26        | 0         |
|                            | D4776-5        | 24       | 1         | 0         |
|                            | D4777-1        | 6        | 68        | 0         |
|                            | MS21042L3      | 12       | 2,964     | 0         |
|                            | MS21209-F615   | 6        | 86        | 0         |

## Part Specifications

Specifications could not be found.

Plex 5/9/19 10:43 AM Dart.lajeunesse.marie



Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                      |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex;"> <div style="flex: 1;">           Operator <input type="checkbox"/><br/>           Manufacturing Process <input type="checkbox"/><br/>           Equip/Tooling <input type="checkbox"/><br/>           Handling/Preservation <input type="checkbox"/><br/>           Material <input type="checkbox"/><br/>           Product Improvement <input type="checkbox"/><br/>           Process Improvement <input type="checkbox"/><br/>           Human Factors <input type="checkbox"/> </div> <div style="flex: 1;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex;"> <div style="flex: 1;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="flex: 1;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="flex: 1;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                        |  |



**Container No: S184096**



**Part: D4775-041**

**Job No: 194853**

**Serial No/Batch: S184096**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K64 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Date: 05/27/19**